



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D5127-3
Job Sheet 202145



Part No: D5127-3

Job Qty: 6 pcs

Part Name: Shim, Small

20 pcs. A.A



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/21/19

Job Tracking No:

Due Date: 11/15/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 14-07-31 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

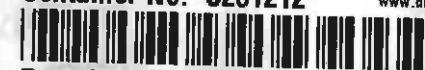
Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	6 pcs	11/15/19	11/15/19	0.00	1.44	Bandsaw - 1		mar L 19/11/13
110	HAAS 4 Axis - B4B	6 pcs	11/15/19	11/15/19	1.00	1.44	HAAS - 1 - B4B		mar L 19/11/17
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	6 pcs	11/15/19	11/15/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		mar L 19/11/17
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		

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Container No: S231212



Part: D5127-3

Job No: 202145

Serial No/Batch: S231212

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/13/10

Dart Aerospace Ltd.
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CANADA
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130 QC 8	6 pcs	11/15/19	0.00 0.00	QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
140 Handfinish - 1-1 Chemical-B4B	6 pcs	11/15/19	0.00 0.14	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 -	

DAS
23
9-89

19/11/18

BEB 19-11-19.

					B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
					QC 7 - 10	
					QC 7 - 13	
141 QC 7	6 pcs	11/15/19	0.00	0.00	QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
					QC 7 - 79	
150 Powdercoat - 1 White GI(A)- B4B	6 pcs	11/15/19	0.00	0.04	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
160 QC 3	6 pcs	11/15/19	0.00	0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	

BP 19-11-22

BP 19-11-22

					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	DAS
					QC 3 - 9	NOV 2 2 2019 40
					QC 3 - 40	9-89
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
170 Packaging 3-1 - Stock - B4B	6 pcs	11/15/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	ST143 68-6 NOV 2 5 2019
					Packaging 3 - 5 - B4B	74
					Packaging 3 - 6 - B4B	DAS
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180 QC 21 - SA	6 pcs	11/15/19	0.00 0.00		QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21 NOV 2 5 2019
					QC 21 - SA - 53	9-89

Part Op 100 - Cut blank:1.510" LONG
Descriptions: 110 - (HAAS CNC Vertical Machine), 1- Machine as per Folio FB333 and Dwg FOLIO REV: A DWG
REV: A - Debur

120 - QC2- Inspect parts off machine FAI/FAIB
130 - QC8- Inspect parts - second check
140 - Chemical Conversion Coat per QSI005 4.1
141 - QC7-Inspect Chemical Conversion Coat
150 - White Gloss(Ref 4.3.5.1) per QSI005 4.3-Alum START TIME: 11:00 OVEN TEMPERATURE: 320
FINISH TIME: 12:50 11/3/18
160 - QC3- Inspect Part Finish
170 - Identify as per dwg & Stock Location:
180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.250X01.000	6061-T6 Bar .250 X 1.00	.7500 ft (.125 ea)	100-Bandsaw - 1	5216335-2.02

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B0.250X01.000	1	28	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Shim, Small	0.750Inches ± 0.030	0.780 0.720	0.743	
2	Shim, Small	0.380Inches ± 0.030	0.410 0.350	0.374	
3	Shim, Small	1.310Inches ± 0.030	1.340 1.280	1.304	
4	Shim, Small	0.830Inches ± 0.010	0.840 0.820	0.830	
5	Shim, Small	0.240Inches ± 0.030	0.270 0.210	0.238	
6	Shim, Small	0.128Inches ± 0.010	0.138 0.118	0.130	
7	Shim, Small	0.064Inches ± 0.010	0.074 0.054	0.060	
8	Shim, Small	0.180Inches + 0.005 - 0.001	0.185 0.179	Diameter 0.180	

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